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of:

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for

Cycloolefin Copolymer Heat Sealable Films and Packaging Incorporating Same

## **CYCLOOLEFIN COPOLYMER HEAT SEALABLE FILMS**

### 5    **Technical Field**

The present invention is directed to heat sealable cycloolefin copolymer (COC) films. The invention further relates to the use of the film in heat sealable laminates and to processes for production of heat sealed containers.

### 10   **Background of the Invention**

Plastic films have widely been employed for use in, such as supermarkets and the like, for prepackaging various products including foods, such as vegetables and the like. *See*, for example, United States Patent No. 6,489,016 which discloses multilayer packaging films of polyolefin. Also disclosing such packaging materials and packages made therefrom are United States Patent Nos. 15 6,383,582; 5,750,262; 5,783,270; and 5,755,081; and Statutory Invention Registration No. H1727. Such prepackaging films serve for covering and enclosing commercial articles, such as foodstuffs including liquid foodstuffs, as individual articles or in a lot allotted or subdivided into small portions placed on a plastic carrier tray or the like. The success of such flexible packaging has been 20 attributed to the broad use of thermoplastic heat sealants that are capable of providing the highest degree of package integrity, security and durability. Furthermore, it is required for the prepackaging film that the film should be transparent and can easily be cut with an adequate extensible elasticity and an ability for adhering onto various surfaces, together with practical performance 25 attributes such as resistance to fogging on the inner face when packaged, resistance to break-through upon heat sealing due to the heated pressing by the sealing bars, restorability from finger pressing and superior heat-sealability.

30        As is also well known, a "heat-seal" refers to the union of two films, e.g., a film and a thermoformed film/container or two portions of the same film, by

bringing the films into contact with one another and then applying sufficient heat and pressure to the contacting regions of the films to cause the films to fuse together. Conventionally, but not necessarily always, the heat-seal is continuous and encircles the product to completely enclose the product within the two films, and is formed by a mechanism that includes a heated element (often referred to as a "seal-head") which is pressed onto the contacting regions of the films from one side of one of the films and typically presses the films against a non-heated backing element so that the films are pressed between the heated element and backing element for a period of time sufficient to effect a heat-seal. Alternatively, the films can be pressed between two heated elements or jaws to effect a heat seal.

The heat seal performance of thermoplastic materials is a complex function of time, temperature and pressure. J. R. de Garavilla, *Tappi Journal*, 191 (June 1995) describes the sealant performance of various ionomer, acid copolymer and metallocene polyethylene resins.

Packaging films from thermoplastic resins are typically made by melt extrusion. For melt extrusion, melt strength and extrusion processability of the polymer resin are some important characteristics. Resins capable of higher extruder output and requiring less energy to convert into film are preferred. Heat sealability at low temperatures (i.e., under 80°C) is beneficial since it is more amenable to many commercial processes and allows for higher production speeds.

An object of the present invention is to provide a film for packaging applications. In particular it is an object of the present invention to provide films that can be heat sealed at relatively low temperatures and methods of packaging comprising films that can be heat-sealed at relatively low temperatures. It is a further object to provide a film which optionally can be laminated to thermoplastic polymers or metals at relatively low temperatures.

### Summary of the Invention

One or more of the above-mentioned objects are achieved by the provision of a film that can be heat sealed at about 50-80°C. The film consists essentially of a cycloolefin copolymer ("COC") wherein the COC polymer has a T<sub>g</sub> in the range  
5 30-55°C. The films exhibit superior sealing properties at low temperatures and surprising hot tack and ultimate seal strength over a broad temperature range making them suitable for a wide variety of applications and particularly robust for packaging applications.

10 The film of the present invention can be laminated in a separate step to one or more additional thermoplastic polymer layers and/or other layers to form a multilayer laminate or the COC polymer can be coextruded along with one or more thermoplastic resins to produce a multilayer laminate. In such multilayer, at least one layer is of the above-noted COC polymer, resulting in a film having a  
15 heat-sealable side made of the above-noted COC and optionally the other side is made of the other polymer. Constructions having more than two layers, but only one heat sealable side, may also be made in a similar manner, in which case, the above-noted COC layer forms an outer, heat sealable layer.

### 20 Brief Description of Drawings

The invention is described in detail below with reference to the **Figures** in which:

**Figure 1** is a plot of Hot-Tack Seal Strength versus sealing temperature for  
25 films of the invention and various other films.

**Figure 2** is a plot of Ultimate Seal Strength versus temperature for various films;

30 **Figure 3** is a plot of Hot-Tack Seal Strength versus sealing temperature for heat sealable films which are blends of commercial polymer and COC polymer;

**Figure 4** is a plot of Ultimate Seal Strength versus sealing temperature for heat sealable films which are blends of commercial polymer and COC polymer;

**Figure 5** is a plot of the Hot Tack Seal Strength of a heat sealable film of a COC polymer of the invention at various sealing temperatures;

**Figure 6** is a plot of Ultimate Seal Strength versus sealing temperature for films of the invention; and

**Figures 7-11** illustrate various laminates and packaging of the invention.

#### Detailed Description of the Invention

The invention is described in detail below by reference to the various **Figures** and examples. Such illustration is for purposes of description only and is not limitative of the invention, the spirit and scope of which appears in the appended claims. Unless otherwise indicated, terms are to be construed in accordance with their ordinary meaning. The term "polymer" or "polymer resin", "polymeric" or the like includes, but is not limited to, homopolymers, copolymers, such as for example, block, graft, random and alternating copolymers, terpolymers, etc., and blends and modifications thereof, unless specifically stated otherwise, e.g. copolymer. "Polymer" or "polymer resin" shall also include all possible molecular configurations of the material. These structures include, but are not limited to, isotactic, syndiotactic and atactic (random) molecular configurations. "Mils" means thousandths of an inch.

T<sub>g</sub>, or glass transition temperature of a polymer, can be tested by various methods. Preferably, T<sub>g</sub> of the polymers of the instant invention is determined according to ASTM D3418-99. The test method consists generally of heating and cooling a polymer in a controlled environment while monitoring the difference in temperature between such polymer and a reference material.

- Hot Tack Force Strength (Newtons) or “hot tack”, the expression for the strength of a heat seal measured at a particular moment before the seal reaches ambient temperature, is measured pursuant to ASTM F1921-98 which is incorporated herein in its entirety by reference. A sample such as a film
- 5 according to the present invention can be heat sealed wherein the resultant seal can be tested for its durability and resistance to disruptive forces while the seal is still hot. In general terms, the testing method includes applying pressure to a sample from two flat heated jaws under defined conditions of temperature, contact time and pressure such that the “sealing temperature” is the maximum temperature
- 10 reached at the interface between the films being sealed while the jaws are in contact with and applying pressure on the films being sealed. After the sample is removed from the jaws but prior to reaching ambient temperature, the force required to essentially break the seal is measured.
- 15 The heat sealing temperature, heat seal temperature and like terminology thus refers to the temperature of the jaws or other sealing implements provided dwell time is sufficient; otherwise the sealing temperature is approximated as the surface temperature of the sealing implement or implements.
- 20 Ultimate seal strength as that term is used herein, also expressed in Newtons is the strength of a heat seal about 30 seconds after heat sealing, as is determined by the same method used to measure hot tack except that a 30 second cooling time is provided before the seal is broken. Sample testing parameters for both hot tack and ultimate seal strength are shown in Table 1 below:

**Table 1**

<b><u>Conditions</u></b>	<b><u>Hot Tack Strength</u></b>	<b><u>Ultimate Seal Strength</u></b>
Seal Pressure:	0.3034 N/mm <sup>2</sup>	0.3034 N/mm <sup>2</sup>
Seal Time:	thickness < 1 mil = 500 ms thickness < 2.5 mil = 1 sec	thickness < 1 mil = 500ms thickness < 2.5 mil = 1 sec
Cool Time (Delay Time):	100 ms	30 seconds
Peel Speed (Clamp Separation Rate):	200 mm/s (1200 cm/min)	200 mm/s (1200 cm/min)
Force Range:	10 Newtons	100 Newtons
Samples Per Setting	3	3
Sample Width:	15 mm, 25 mm, 1"	15 mm, 25 mm, 1"
Sample Thickness:	Variable	Variable
Temperature Range:	Variable	Variable

Alternate measuring means can be used to determine hot tack, for example ASTM  
5 D3706-88(2000), but for convenience results obtained pursuant to ASTM F1921-  
98 are used herein.

As used herein, the term "heat-seal" or the like terminology refers to the  
union of at least two films by bringing the films into contact, or at least close  
10 proximity, with one another and then applying sufficient heat and pressure to a  
predetermined area (or areas) of the films to cause the contacting surfaces of the  
films in the predetermined area to become molten and intermix with one another,  
thereby forming an essentially inseparable bond between the two films in the  
predetermined area when the heat and pressure are removed therefrom and the  
15 area is allowed to cool. The terms "film" and "sheet" as used herein each refer to  
any expanse of material, whether a single layer or multiple layers, and are not  
limited as to thickness or configuration. While these terms often bring to mind a  
flat shape, the films of the present invention may be otherwise configured; for  
example, an annular film according to the present invention may be extruded from  
20 a die, and this film may be used in that configuration or may be subsequently slit

open into a flat or curled sheet without departing from the essence of the present invention.

As used herein, the term "multilayer film" refers to a thermoplastic material, generally in sheet or web form, having one or more layers formed from polymeric or other materials which are bonded together by any conventional or suitable method, including one or more of the following methods: coextrusion, extrusion coating, lamination, vapor deposition coating, solvent coating, emulsion coating, or suspension coating.

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As used herein, the terms "coextrusion," "coextrude," and the like refer to the process of extruding two or more materials through a single die with two or more orifices arranged so that the extrudates merge and weld together into a laminar structure before chilling, i.e., quenching. Coextrusion can be employed in film blowing, free film extrusion, and extrusion coating processes.

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As used herein, the phrase "melting point" refers generally to the temperature at which a material transitions from solid to liquid.

In one embodiment, the present invention discloses a heat sealable film or sheet consisting essentially of COC polymer. The COC polymer has a Tg in the temperature range 30-55°C.

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Suitable films may have, for example, from about 24 to about 30 mole percent norbornene and from about 76 to about 70 mole percent ethylene.

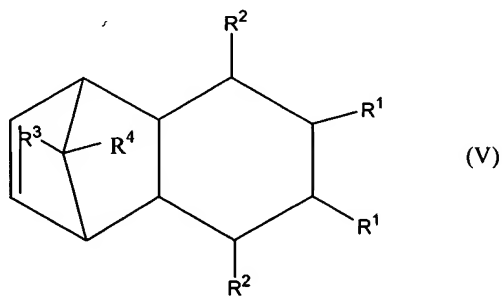
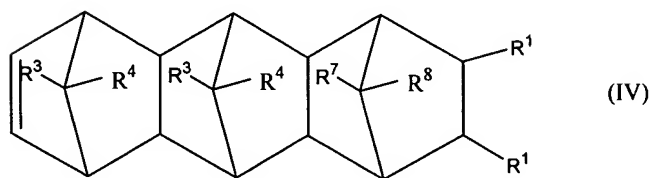
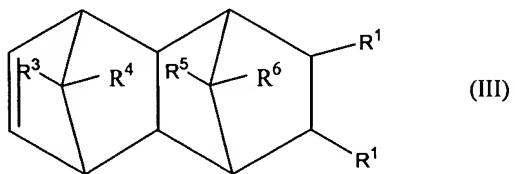
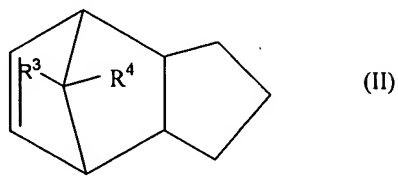
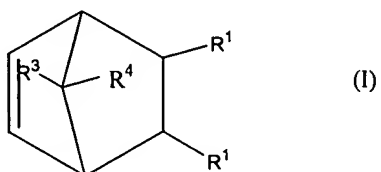
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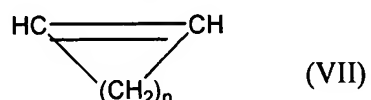
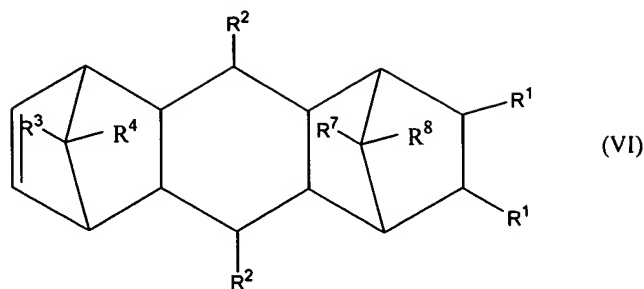
The cycloolefin polymer utilized as heat sealable layer in the invention is a cycloolefin copolymer. Useful cycloolefin copolymers are known in the art. For example, United States Patent No. 6,068,936 (Assignee: Ticona GmbH) and United States Patent No. 5,912,070 (Assignee: Mitsui Chemicals, Inc.) disclose

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several cycloolefin polymers and copolymers, the disclosures of which are incorporated herein in their entirety by reference.

5 The cycloolefin copolymer useful in the invention is a copolymer of an acyclic olefin and a cyclic olefin (or "cycloolefin") monomer which cyclic olefin monomer has (i) the polycyclic structure of formula I, II, III, IV, V or VI, or (ii) the monocyclic structure of the formula VII:





wherein  $R^1$ ,  $R^2$ ,  $R^3$ ,  $R^4$ ,  $R^5$ ,  $R^6$ ,  $R^7$  and  $R^8$  are the same or different and are H, a  $C_6$ -  
 5  $C_{20}$ -aryl or  $C_1$ - $C_{20}$ -alkyl radical or a halogen atom, and  $n$  is a number from 2 to  
 10. Examples of such cyclic olefin monomers are norbornene, dimethyl-  
 octahydro-naphthalene, cyclopentene and (5-methyl)norbornene and the like, or  
 mixtures thereof. Examples of suitable acyclic olefin monomers are ethylene,  
 propylene, butylene and the like, or mixtures thereof. Preferred cyclic olefin is  
 10 norbornene, and preferred acyclic olefin is ethylene or propylene. An especially  
 preferred cycloolefin copolymer is a copolymer of norbornene and ethylene,  
 wherein said cycloolefin copolymer contains about 10-90 mole percent of  
 norbornene residue and about 90-10 weight percent of ethylene residue. Several  
 such polymers are available under the tradename TOPAS<sup>®</sup> from Ticona, Summit,  
 15 New Jersey.

Another embodiment of the invention discloses a cycloolefin copolymer of  
 norbornene and ethylene in a mole percent ration of about 15-30% norbornene and  
 about 70-85 mole percent ethylene, said copolymer having a  $T_g$  in the range of  
 20 about 30-55°C.

The cycloolefin polymers can be prepared with the aid of transition-metal  
 catalysts, e.g. metallocenes. Suitable preparation processes are known and  
 described, for example, in DD-A-109 225, EP-A-0 407 870, EP-A-0 485 893,

United States Patent Nos. 6,489,016, 6,008,298, 6,608,936, and 5,912,070, the disclosures of which are incorporated herein in their entirety by reference.

5 Molecular weight regulation during the preparation can advantageously be effected using hydrogen. Suitable molecular weights can also be established through targeted selection of the catalyst and reaction conditions. Details in this respect are given in the abovementioned specifications.

10 Cycloolefin copolymers which are suitable for the purposes of the present invention have a mean molecular weight  $M_w$  (weight average) in the range from 1000 to 200,000, preferably from 100,000 to 150,000. Suitable COCs can be characterized by their glass transition temperature,  $T_g$ , which, for the purposes of their inventive use as resins for low temperature heat sealable layers, is in the range from 30 to 55°C. Such suitable COC polymers are available under the  
15 TOPAS® brand from Ticona, Incorporated, Summit, New Jersey. Additionally, preparation of COC copolymers from suitable monomers is disclosed, for example, in United States Patent No. 6,489,016. The  $T_g$  of the polymers was determined by the Perkin Elmer "half Cp extrapolated" (the "half Cp extrapolated" reports the point on the curve where the specific heat change is half  
20 of the change in the complete transition) following the ASTM D3418 "Standard Test Method of Transition Temperatures of Polymers by Thermal Analysis" (American Society for Testing of Materials, Philadelphia, Pennsylvania) noted above.

25 The above- described low temperature heat sealable COC films can be laminated to or coextruded with other thermoplastic layers. The polymers for such additional layers can be selected from the group consisting of polyolefin, polyamide, polyester, polyamide (including nylon), polyketone, polyketoamide, polycarbonate, ethylene/vinyl alcohol copolymer (EVOH), polyurethane,  
30 polyether, polyvinyl, polypropylene, cyclic olefin homopolymer and cyclic olefin copolymer and combinations thereof. Examples of suitable polymers are poly (m-

- xylene-adipamide) (MXD6), poly(hexamethylenesebacamide), poly(hexamethylene-adipamide) and poly(-caprolactam), polyesters such as poly(ethylene terephthalate) and polybutylene terephthalate, polyurethanes, polyacrylonitriles, ethylene vinyl alcohol copolymers, ethylene vinyl acetate copolymers, polyesters grafted with maleic anhydride, PVdC, aliphatic polyketone, and LCP (liquid crystalline polymers). A suitable polyketone is exemplified by Carillon<sup>®</sup>, which is produced by Shell. A suitable liquid crystalline polymer is exemplified by Vectra<sup>®</sup>, which is produced by Ticona.
- 10        Some of the polyethylenes useful as thermoplastic polymers for lamination in accordance with this invention are referred to by terms such as LDPE, LLDPE, LMDPE, VLDPE, ULDPE, and the like. LDPE is a low density polyethylene homopolymer. Ethylene/alpha-olefin copolymers generally have a density in the range of from about 0.86 g/cc to about 0.94 g/cc. The term linear low density
- 15        polyethylene (LLDPE) is generally understood to include that group of ethylene/alpha-olefin copolymers which fall into the density range of about 0.915 to about 0.94 g/cc. Sometimes linear polyethylene in the density range from about 0.926 to about 0.94 g/cc is referred to as linear medium density polyethylene (LMDPE). Lower density ethylene/alpha-olefin copolymers may be referred to as
- 20        very low density polyethylene (VLDPE, typically used to refer to the ethylene/butene copolymers available from Union Carbide with a density ranging from about 0.88 to about 0.91 g/cc) and ultra-low density polyethylene (ULDPE, typically used to refer to the ethylene/octene copolymers supplied by Dow Chemical Company).
- 25        The thickness of the other thermoplastic films can be in the range 10 to 250 microns. Typical lamination conditions are adhesive lamination conditions. In addition to the other thermoplastic films described earlier, other useful thermoplastics are OPET ("Biaxially oriented polyethylene terephthalate") and
- 30        OPP ("Biaxially oriented polypropylene"). Often OPET and OPP are reverse printed (printed on the side to be laminated to give high quality protected

graphics). Also common is aluminum foil laminated to a sealant film. E.g. Capri Sun<sup>®</sup> (reverse printed OPET/adhesive/foil/adhesive/sealant).

Alternatively, the COC polymer described herein can be coextruded with  
5 other suitable thermoplastic polymers to produce a heat sealable laminate which  
can be heat sealed on the COC film side at low temperatures. A typical two-layer  
laminate of the present invention can be formed by extrusion or coextrusion of the  
COC polymer and the other thermoplastic polymer through a suitable die. The  
total thickness of the laminate can vary within broad limits and depends on the  
10 intended application.

Extrusion processes *per se* are well-known. In the inventive process, the  
COC and the other thermoplastic polymer are compressed and melted in an  
extruder, and subsequently extruded through a flat-film die, and the resultant film  
15 is taken off over one or more rolls for solidification, oriented if desired,  
subsequently heat-set if desired, and, corona- or flame-treated on the surface  
intended for treatment, if desired. Alternatively to a flat film process, a tubular  
film can be produced through the use of an annular die. The tubular film can be  
either single or multilayer. The tube can be quenched and collected for use in the  
20 final tubular shaped container or stretched and slit into a film.

In one preferred method for making a multi-component film or sheet  
according to the present invention, two extruders are used to extrude the two  
polymers having different melting points. A combining block is used to guide the  
25 polymers into a single die so that the lower melting COC polymer forms the  
outermost layers. In another preferred embodiment of this method, a multi-  
manifold die is used instead of the combining block and die. When more than two  
polymers are used, one extruder is needed for each polymer. The extruders, dies,  
and combining blocks useful in the practice of the present invention are those  
30 well-known to those skilled in the art. It is contemplated that a wide variety of  
such equipment may be used in various combinations, the choice of which partly

will depend upon the polymers that are used and the number and thicknesses of the layers that are desired.

5        Films are suitably prepared by way of flat die or blown film techniques described in Kirk-Othmer, *Encyclopedia of Chemical Technology*, Fourth Edition (1993), Volume 10, pp. 775-778, the disclosure of which is incorporated herein by reference.

10       The main variations of melt extrusion are the slot (or flat) die-cast film process and the blown films process. These may be combined with one or more steps such as coextrusion wherein multilayer film or sheet is formed, biaxial orientation, and in-line coating.

15       The simplest form of melt extrusion is the use of a slot die to form the molten polymer into a thin flat profile which is then quenched immediately to a solid state. This is usually done by contacting the hot web very quickly on a chilled roll or drum. A liquid quenching bath may be used in place of or contiguous to the chill roll. Depending on the polymer type or formulation, the quenched web is generally substantially amorphous. In some cases, the web may  
20       be drawn down in thickness by overdriving the quenching roll relative to the extrusion velocity. The most critical factor in the slot-film process is the design of the die. The control of transverse gauge is extremely important and requires some form of cross-web gauge adjustment. Mechanical alternation of the die gap across the web may be done by using precisely controlled bolt action on the die lips, or  
25       by controlled application of heat in small increments across the die. Interior die geometry must be carefully designed to accommodate the flow and shear characteristics of the particular polymer being used. Care must be taken to prevent melt fracture by adjusting die characteristics to extrusion rate, drawdown, viscosity, and temperature.

The blown or tubular film process provides a low cost method for production of thin films. In this process, the hot melt is extruded through an annular circular die either upward or downward and, less frequently, horizontally. The tube is inflated with air to a diameter determined by the desired film properties and by practical handling considerations. This may vary from as small as a centimeter to over a meter in diameter.

As the hot melt emerges from the die, the tube is expanded by air to two or three times its diameter. At the same time, the cooled air chills the web to a solid and impact properties. The point of air impingement and the velocity and temperature of the air must all be controlled to give the optimum physical properties to the film. The film tube is collapsed within a V-shaped frame of rollers and is nipped at the end of the frame to trap the air within the bubble. The nip rolls also draw the film away from the die. The draw rate is controlled to balance the physical properties with the transverse properties achieved by the blow draw ratio. The tube may be wound as such or may be slit and wound onto one or more rolls. The blown film technique is used to produce tailored film products by coextruding one or more polymer types in two or more layers of melt. In this fashion the benefits of specific polymer types or formulations may be combined. Thus high cost barrier resins may be combined with a low cost thicker layer of standard resin to achieve an optimum barrier film at lower cost. Thin slip-control layers may be used on the surface of a bulk layer of optically clear resin to obtain an aesthetic film with good handleability. Lower melting outer layers of the present invention are used to provide heat sealing.

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In yet another embodiment of the invention, the multilayer laminate can be prepared by adhesion rather than extrusion.

In another embodiment of the invention, the layers of the laminate can be prepared by molding processes such as, for example, blow molding, injection molding and the like.

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Another embodiment of the invention relates to a method of bringing together a COC polymer of the invention with itself, another COC polymer film, another thermoplastic polymer film, or a combination of the above in one or more forms. The method comprises bringing together the film or films desired into  
5 intimate physical contact, and applying pressure at about 50-80°C.

The inner layers of the film or sheet need not all have the same melting point, but they should have melting points sufficiently higher than the melting point of the outer COC layer so that the outer layer may be melted without  
10 melting that inner layer. This arrangement of layers allows the outer layer to be melt laminated or bonded or sealed to other objects while the inner layers maintain their shape, structure, rigidity, and other physical properties.

Alternately, two COC polymer films of the present invention may be melt  
15 or heat sealed to each other.

In yet another embodiment, the COC polymer film can be folded back onto itself and heat sealed.

20 Other useful processes of forming packages with the inventive films include, for example, instances where such packages are formed by first thermoforming the inventive polymeric film, laminate or foamed sheet into a desired shape for containment of a product therein, positioning the product within the so-formed container, placing another object (e.g. a polymeric film, paper,  
25 cardboard, metal object and the like) and then heat sealing the container and object together in such a manner that the product may be enclosed between the object and the container. In yet another process, the inventive polymeric film, laminate or foamed sheet can be formed into a pouch, heat sealing closed all but one of the open edges thereof, filling the pouch with a product (e.g., a solid or a  
30 liquid) via the open edge, and then heat sealing closed the remaining open edge to enclose the product. Such processes are well known in the art of packaging.

Multilayer films in accordance with the present invention may be cross-linked if desired, e.g., to increase the structural strength of the film at elevated temperatures and/or to increase the force at which the material can be stretched before tearing apart. Cross-linking is preferably done by irradiation, i.e.,  
5 bombarding the film with particulate or non-particulate radiation such as high-energy electrons from an accelerator or cobalt-60 gamma rays. Any conventional cross-linking technique may be used. For example, electronic cross-linking may be carried out by curtain-beam irradiation. Chemical cross-linking techniques may also be employed, e.g., by the use of peroxides.

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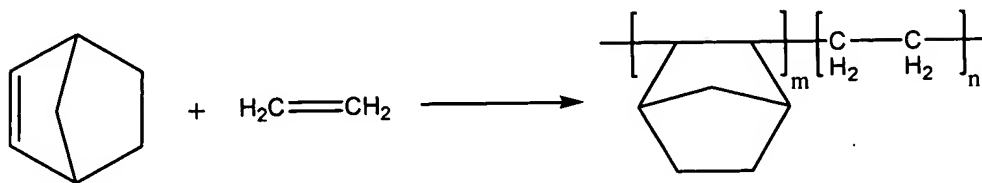
The present invention is not limited with respect to the thickness of the layers or of the multi-layer sheet as a whole, nor with respect to the number of layers in the sheet. These variables can be determined based upon need and based upon the capabilities of the equipment that is available.

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The invention is described in detail below by reference to the various examples. Such illustration is for purposes of description only and is not limitative of the invention, the spirit and scope of which appears in the appended claims. Unless otherwise indicated, terms are to be construed in accordance with  
20 their ordinary meaning. Many variations of the present invention will occur to those skilled in the art. The present invention is not limited to the embodiments illustrated and described herein, but encompasses all the subject matter within the scope of the appended claims.

Example 1

Preparation of a Cyclo-Olefin/Ethylene Copolymer (See United States Patent No. 6,008,298).



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A clean and dry 75 dm<sup>3</sup> polymerization reactor with a stirrer was flushed with nitrogen and then with ethylene and filled with 12 kg of norbornene and 15 dm<sup>3</sup> of toluene. 300 ml of triisobutylaluminum solution (20% w/w in toluene) were added. The ethylene pressure was adjusted to an increased pressure of 18 bar. The reaction temperature was adjusted to 70°C. 20 mg of isopropenyl-(cyclopentadienyl)(1-indenyl)-zirconium dichloride were dissolved in 500 ml of a toluene solution of methylaluminoxane (10% by weight of methylaluminoxane of molecular weight 1300 g/mol according to cryoscopic determination) and the solution was then metered into the reactor. The ethylene pressure was kept at 18 bar by topping up. After a polymerization time of 90 minutes, the contents of the reactor were emptied into a 150 dm<sup>3</sup> stirred tank into which 500 g of Celite and 200 ml of water in 50 dm<sup>3</sup> of a hydrogenated diesel oil fraction (Exxsol, boiling range 100 to 120°C from Exxon) had been initially introduced. The mixture was stirred at 60°C for 20 minutes. A filter cake of 500 g of Celite suspended in 10 dm<sup>3</sup> of Exxsol was built up on the filter fabric of a 120 dm<sup>3</sup> pressure suction filter. The polymer solution was filtered over the pressure suction filter. A nitrogen pressure of 2.8 bar was built up over the solution. The mixture was then filtered over seven filter candles (Fluid Dynamics, Dynalloy XS 64.5 µm 0.1 m<sup>2</sup>/candle), which were mounted in a steel housing. The polymer solution was stirred into 500 dm<sup>3</sup> of acetone by means of a disperser (Ultraturrax) and thereby precipitated. The suspension was circulated over a 680 dm<sup>3</sup> stirred pressure suction filter with the bottom valve open. After the bottom valve had been closed, the residue was washed three times with 200 dm<sup>3</sup> of acetone. After the last washing, the product

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was pre-dried in a stream of nitrogen at 60°C and dried in a drying cabinet for 24 hours under 0.2 bar and at 80°C 5.37 kg of polymer were obtained. The viscosity number was 51 ml/g and the glass transition temperature was 105°C.

- 5 By varying the norbornene content in the above-described process, COC polymers of varying Tg could be prepared. Generally, reducing the norbornene content and increasing the ethylene correspondingly reduced the Tg. In generally, the Tg of the polymers of the invention follow the relationship

10 Norbornene Content =  $\frac{(T_g + 65)}{4}$

4.

The following Table 2 lists the various COC polymers that were prepared thus, along with their monomer ratios and Tg.

15 Table 2 – Tg of Selected Polymers

Description	Designation	Norbornene Content, Mole %	Tg °C
COC Copolymer	COC A	36%	78
COC Copolymer	COC 1	25%	33
COC Copolymer	COC 2	25%	33
COC Copolymer	COC 3	25%	33
COC Copolymer	COC 4	27%	44
Claim ?? Copolymer	Polymer B	0	127
Commercial Heat-Sealable Film	Polymer C	0	--
LLDPE	Polymer D	0	--
LLDPE	Polymer E	0	--

- 20 As previously mentioned, the strength and durability of a heat seal is essential for packaging purposes. For example, the strength of a package can be correlated with the strength of a heat seal. Heat seals made with the films of the present invention are surprisingly strong even at low heat sealing temperatures as demonstrated by their hot tack force strength and ultimate seal strength.

Specific hot tack strength measurement results of various COC films of the present invention, blends and commercial films are shown in Samples 1 through 21 below and ultimate seal strength measurements of various COC polymers of the present invention, blends and commercial films are shown below in Samples 21 through 29. The data are also plotted in **Figures 1 through 5**. The Samples are for illustrative purposes only and are not limitative of the invention.

Specific testing conditions for hot tack measurements are shown in the Hot Tack Conditions chart below and apply to Samples 1 through Sample 13 of Table 3.

**Hot Tack Conditions**

Seal Pressure =	0.3034 N/mm <sup>2</sup> or 44 psi
Seal Time =	1.0 s
Cool Time =	0.1 s
Peel Speed =	200 mm/s
Sample Width =	1.0" or 25.4 mm
Sample Thickness =	2 mil

15

**Table 3-Hot Tack Strength**

**Sample 1: 80% Polymer D + 20% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	1.464	No Seal
100	1.976	No Seal
110	6.685	Peeled at Seal Zone

20

**Sample 2: 60% Polymer D + 40% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	1.555	No Seal
100	2.367	Weak Seal
110	6.052	Peeled at Seal Zone

**Sample 3: 40% Polymer D + 60% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	1.846	No Seal
100	1.938	No Seal
110	4.032	Slight Elongation at Seal Zone
120	5.954	Peeled at Seal Zone

**Sample 4: 20% Polymer D + 80% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	1.594	No Seal
100	2.102	No Seal
110	5.467	Slight Elongation/Peeling at Seal Zone
120	6.512	Peeled at Seal Zone

5

**Sample 5: COC 3 + .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
50	1.055	No Seal
55	5.803	Good Seal
60	21.872	Peeled From Laminate

**Sample 6: COC 4 + .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
60	0.393	No Seal
65	5.151	Good Seal
70	30.330	Peeled at Seal Zone

**Sample 7: COC 2 + .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
55	1.259	No Seal
60	6.523	Good Seal
65	18.179	Peeled From Laminate

10

**Sample 8: COC 1 + .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
50	1.109	No Seal
55	7.707	Good Seal
60	17.440	Peeled from Laminate

**Sample 9: 100% COC A**

<b><u>Temperature °C</u></b>	<b><u>Avg Force</u></b>	<b><u>Seal Type</u></b>
90	0.218	No Seal
100	4.040	Weak Seal
110	9.796	Adhesive Seal Failure
120	5.194	Material Break
130	3.546	Material Break

5

**Sample 10: Polymer C**

<b><u>Temperature °C</u></b>	<b><u>Avg Force</u></b>	
90	0.279	
100	0.722	
110	5.125	
120	12.934	
130	11.279	
140	7.229	

**Sample 11: 100% Polymer D**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.248	No Seal
100	0.293	No Seal
110	1.049	No Seal
120	3.274	Weak Seal
130	4.777	Weak Seal/Partial Peeling

**Sample 12: 100% Polymer E**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.255	No Seal
100	0.267	Weak Seal
110	4.101	Peeled at Seal Zone
120	2.690	Peeled at Seal Zone

**Sample 13: Polymer B**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
120	5.6	

5

Specific testing conditions for additional hot tack measurements are shown in the chart below and apply to Samples 14 through Sample 21 of Table 4.

**Hot Tack Conditions**

Seal Pressure =	0.3034 N/mm <sup>2</sup> or 44 psi
Seal Time =	1.0 s
Cool Time =	.1 s
Peel Speed =	200 mm/s
Sample Width =	1.0" or 25.4 mm
Sample Thickness =	2 mil

10

**Table 4 Hot Tack Strength****Sample 14: 80% Polymer D + 20% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	1.464	No Seal
100	1.976	No Seal
110	6.685	Peeled at Seal Zone

**Sample 15: 60% Polymer D + 40% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	1.555	No Seal
100	2.367	Weak Seal
110	6.052	Peeled at Seal Zone

15

**Sample 16: 40% Polymer D + 60% COC 1**

<u>Temperature °C</u>	<u>Avg. Force</u>	<u>Seal Type</u>
90	1.846	No Seal
100	1.938	No Seal
110	4.032	Slight Elongation at Seal Zone
120	5.954	Peeled at Seal Zone

**Sample 17: 20% Polymer D + 80% COC 1**

<u>Temperature °C</u>	<u>Avg. Force</u>	<u>Seal Type</u>
90	1.594	No Seal
100	2.102	No Seal
110	5.467	Slight Elongation/Peeling at Seal Zone
120	6.512	Peeled at Seal Zone

5

**Sample 18: COC 3 + .2% Licowax C**

<u>Temperature °C</u>	<u>Avg. Force</u>	<u>Seal Type</u>
50	1.055	No Seal
55	5.803	Good Seal
60	21.872	Peeled From Laminate
65	15.557	Peeled From Laminate
70	13.321	Peeled From Laminate
75	11.893	Partial Peeled From Laminate
80	11.891	Peeled From Laminate
85	12.817	Peeled From Laminate
90	9.904	Peeled at Seal Zone
100	9.109	Peeled at Seal Zone
110	7.389	Peeled at Seal Zone
120	7.180	Peeled at Seal Zone
130	7.379	Peeled at Seal Zone
140	7.879	Peeled at Seal Zone
150	5.868	Peeled at Seal Zone
160	6.824	Peeled at Seal Zone
170	8.198	Peeled at Seal Zone
180	7.695	Peeled at Seal Zone

**Sample 19: COC 4 + .2% Licowax C**

<u>Temperature °C</u>	<u>Avg. Force</u>	<u>Seal Type</u>
60	0.393	No Seal
65	5.151	Good Seal
70	30.330	Peeled at Seal Zone
75	8.277	Peeled at Seal Zone
80	14.568	Peeled at Seal Zone
90	14.558	Peeled from Laminate
100	7.067	Peeled at Seal Zone
110	10.883	Peeled at Seal Zone
120	7.751	Peeled at Seal Zone
130	8.885	Peeled at Seal Zone
140	8.467	Peeled from Laminent
150	6.140	Peeled at Seal Zone
160	6.340	Peeled at Seal Zone
170	3.806	Peeled at Seal Zone

**Sample 20: COC 2 + .2% Licowax C**

<u>Temperature °C</u>	<u>Avg. Force</u>	<u>Seal Type</u>
55	1.259	No Seal
60	6.523	Good Seal
65	18.179	Peeled From Laminate
70	15.778	Peeled From Laminate
75	12.007	Peeled at Seal Zone
80	11.689	Peeled at Seal Zone
90	7.912	Peeled at Seal Zone
100	8.724	Peeled at Seal Zone
110	6.102	Peeled at Seal Zone
120	7.631	Peeled at Seal Zone
130	9.070	Peeled from Laminent
140	7.618	Peeled at Seal Zone
150	6.918	Peeled at Seal Zone
160	7.910	Peeled at Seal Zone
170	5.835	Peeled at Seal Zone
180	6.294	Peeled at Seal Zone

**Sample 21: COC 1 + .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
50	1.109	No Seal
55	7.707	Good Seal
60	14.597	Peeled from Laminate
65	15.357	Peeled at Seal Zone
70	12.717	Peeled from Laminate
75	12.068	Peeled at Seal Zone
80	10.140	Peeled at Seal Zone
90	6.808	Peeled at Seal Zone
100	6.760	Peeled at Seal Zone
110	5.608	Peeled at Seal Zone
120	5.808	Peeled at Seal Zone
130	4.795666667	Peeled at Seal Zone
140	4.604666667	Peeled at Seal Zone
150	5.32	Peeled at Seal Zone
160	4.510333333	Peeled at Seal Zone
170	4.129	Peeled at Seal Zone
180	5.524	Peeled at Seal Zone

- Specific testing conditions for ultimate seal strength measurements are
- 5 shown in the chart below and apply to Samples 22 through Sample 34 of Table 5.

**Ultimate Seal Conditions**

Seal Pressure =	0.3034 N/mm <sup>2</sup> or 44 psi
Seal Time =	1.0 s
Cool Time =	30 s
Peel Speed =	200 mm/s
Sample Width =	1.0" or 25.4 mm
Sample Thickness =	2 mil

**Table 5 Ultimate Seal Strength**

10

**Sample 22: 80% Polymer D + 20% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.817	No Seal
100	3.039	No Seal
110	30.059	Peeled From Laminate

**Sample 23: Polymer D: 60% + 40% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.949	No Seal
100	4.146	Weak Seal
110	32.684	Peeled From Laminate

**Sample 24: Polymer D: 40% + 60% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.761	No Seal
100	1.580	No Seal
110	26.899	Elongation at Seal Zone
120	31.349	Elongation at Seal Zone

5

**Sample 25: 20% Polymer D + 80% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.667	No Seal
100	2.503	No Seal
110	5.109	Weak Seal
120	32.607	Elongation at Seal Zone

**Sample 26: COC 3 + .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
60	1.015	No Seal
65	21.595	Good Seal
70	32.442	Peeled from Laminate
75	36.354	Elongation at Seal Zone

**Sample 27: COC 4 + .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
60	0.071	No Seal
70	1.769	No Seal
80	11.064	Good Seal
90	28.482	Strong Seal, Slipped From Grip

10

**Sample 28: COC 2 + .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
60	0.470	No Seal
70	21.652	Good Seal
80	40.495	Peeled From Laminate

**Sample 29: COC 1 + .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
60	0.557	Good Seal
70	26.838	Good Seal
80	31.203	Peeled at Seal Zone

5

**Sample 30: 100% COC A**

<b><u>Temperature °C</u></b>	<b><u>Avg Force</u></b>	<b><u>Seal Type</u></b>
90	0.113666667	No Seal
100	1.108	Weak Seal
110	10.90233333	Adhesive Seal Failure
120	51.994	Clamps Timed Out, Seal Not Peeled
130	53.98666667	Clamps Timed Out, Seal Not Peeled
130		Clamps Timed Out, Seal Not Peeled
140	48.4950	Seal Pulled From Laminant

**Sample 31: Polymer C**

<b><u>Temperature °C</u></b>	<b><u>Avg Force</u></b>	<b><u>Seal Type</u></b>
100	2.57	Faint Seal
110	41.60	Good Seal
120	57.10	Good Seal (material pulled out of grips)
130	56.48	Good Seal (material pulled out of grips)

**Sample 32: 100% Polymer D**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.085	No Seal
100	3.704	Weak Seal
110	23.714	Mostly Peeled From Laminant
120	22.821	Peeled From Laminant

**Sample 33: 100% Polymer E**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.213	No Seal
100	1.655	No Seal
110	25.851	Peeled Partially From Laminant
120	25.598	Peeled From Laminant

5

**Sample 34: Polymer B**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
100	29	

Specific testing conditions for additional ultimate seal strength measurements are shown in the chart below and apply to Samples 35 to 42 of Table 6.

10

**Ultimate Seal Conditions**

Seal Pressure =	0.3034 N/mm <sup>2</sup> or 44 psi
Seal Time =	1.0 s
Cool Time =	30 s
Peel Speed =	200 mm/s
Sample Width =	1.0" or 25.4 mm
Sample Thickness =	2 mil

**Table 6 Ultimate Seal Strength****Sample 35: 80% Polymer D + 20% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.817	No Seal
100	3.039	No Seal
110	30.059	Peeled From Laminate

**Sample 36: 60% Polymer D + 40% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.949	No Seal
100	4.146	Weak Seal
110	32.684	Peeled From Laminate

5

**Sample 37: 40% Polymer D + 60% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.761	No Seal
100	1.580	No Seal
110	26.899	Elongation at Seal Zone
120	31.349	Elongation at Seal Zone

**Sample 38: 20% Polymer D + 80% COC 1**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
90	0.667	No Seal
100	2.503	No Seal
110	5.109	Weak Seal
120	32.607	Elongation at Seal Zone

10

**Sample 39: COC 3+ .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
60	1.015	No Seal
70	32.442	Peeled from Laminate
75	36.354	Elongation at Seal Zone
80	38.135	Peeled from Laminate
90	35.974	Peeled from Laminate
100	28.749	Elongation at Seal Zone
110	28.890	Elongation at Seal Zone
120	28.676	Elongation at Seal Zone
130	27.608	Peeled from Laminate
140	27.906	Peeled from Laminate

**Sample 40: COC 4 + .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	<b><u>Seal Type</u></b>
60	0.071	No Seal
65	0.265	No Seal
70	1.769	No Seal
75	7.960	Good Seal
80	11.064	Good Seal
90	32.782	Strong Seal, Slipped From Grip
100	39.560	Peeled from Laminate
110	32.181	Good Seal
120	29.050	Good Seal
130	33.337	Peeled from Laminate
140	26.576	Peeled from Laminate

**Sample 41: COC 2 + .2% Licowax C**

<b><u>Temperature °C</u></b>	<b><u>Avg. Force</u></b>	
60	0.470	No Seal
65	1.668	Weak Seal
70	21.652	Good Seal
75	28.166	Good Seal
80	40.495	Peeled From Laminate
90	37.831	Peeled From Laminate
100	34.475	Peeled From Laminate
110	32.837	Peeled From Laminate
120	30.756	Peeled From Laminate
130	28.964	Peeled from Laminate
140	26.247	Peeled from Laminate
150	24.841	Peeled from Laminate
160	27.705	Peeled from Laminate

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**Sampl 42: COC 1 + 2% Licowax C**

<b>Temperature °C</b>	<b>Avg. Force</b>	<b>Seal Type</b>
60	0.557	No Seal
65	2.447	Good Seal
70	26.838	Good Seal
75	26.683	Strong Seal, Slipped from Grip
80	31.203	Peeled at Seal Zone
90	37.009	Peeled at Seal Zone
100	42.613	Peeled From Laminate
110	38.248	Peeled From Laminate
120	32.195	Peeled From Laminate
130	27.080	Peeled from Laminate
140	26.525	Peeled from Laminate

Representative data from Samples 1-42 appears in **Figures 1-6** hereto.

5           It is seen from Samples 1 through 29 and **Figures 1 and 2** that the COC films of the invention have high hot-tack strength at low temperature as well as high ultimate strength even when sealed at temperatures as low as 65°C or so. The term "Good seal" in the Tables in the right hand column indicates that the film referred to exhibited high hot tack strength as well as ultimate strength even  
10 when heat sealed at low temperatures (under 65°C). Coupled with its high volume capability for systems which are extrusion-limited, the films of the invention provide a unique combination of desirable properties for heat sealing films. Moreover, good seal properties are achieved over a wide temperature range indicating the films are much less sensitive to processing conditions than are prior  
15 art films as is seen in **Figures 5 and 6**.

**Figures 3 and 4** demonstrate that when the heat sealable COC film comprises a blend of a COC polymer along with commercial polymers (instead of the COC polymers of the invention), the hot tack strength and the ultimate seal  
20 strength are inferior.

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**Figure 5** shows that hot tack strength is maintained over a broad temperature range for heat sealable COC polymer films of the invention.

**Figure 6** shows that the COC films of the invention have high ultimate  
5 seal strength over a broad temperature range as well.

Yet other aspects of the invention relate to laminates and packages ("receptacles") formed by using the inventive heat sealable films of the invention, as well as methods of preparing such package or packaging material. The COC  
10 polymer film of the invention has excellent suitability for packing foods or other consumable items. It is also highly suitable for use in the industrial sector, e.g. for producing hot-stamping foils or as a label film. Laminates and packages may be made by any suitable technique such as those described in United States Patent No. 5,755,081 and United States Patent No. 5,783,270, the disclosures of which  
15 are incorporated herein by reference. For instance:

**Figure 7** hereto shows a suitably prepared two layer, heat bonded laminate including a thermoplastic layer 10 as well as a heat sealable COC layer 20;

20 **Figure 8** hereto shows a suitably prepared, four layer laminate including a thermoplastic layer 10, a COC layer 20, an optional layer 25 which may include metal, paper, thermoplastic or the like and another COC heat sealable layer 20';

**Figure 9** hereto shows a suitably prepared, five layer laminate similar to  
25 the laminate of **Figure 8**, further including a printed layer 23;

**Figure 10** hereto illustrates a suitably prepared, five layer laminate similar to the laminate of **Figure 8**, further including an adhesive layer 22; and

**Figure 11** shows a package **5** comprising a film or laminate of the present invention which may be any of the laminates of **Figures 7** through **10**, wherein the film is heat sealed at periphery **28**.

- 5            Modifications to the specific embodiments described above within the spirit and scope of the present invention, as is set forth in the appended claims, will be readily apparent to those of skill in the art.